



Dart Aerospace Ltd.
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D3172-041
Job Sheet 202889



Part No: D3172-041

Job Qty: 1 pcs

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D 11.04.04 added pressure wash DD VERF:EC IPP REV:E 16.11.03 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	1 pcs	11/29/19		0.00	25.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	11/29/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



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Container No: S232782



Part: D3172-041

Job No: 202889

Serial No/Batch: S232782

Revision: rev.D

Inspector:

Various STC's

Date: 11/18/19

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						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
130 Handfinish - 2-1 Pressure-B4B	1 pcs	11/29/19	0.00	0.38		Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	BL 19 11-26
						Handfinish - 2 - 4 - B4B	
140 Powdercoat - 1 White GI(A)-B4B	1 pcs	11/29/19	0.00	1.04		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 19 11-26
						Powdercoat - 4 - B4B	
145 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	

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					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150 QC 21 - SA	1 pcs	11/29/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	DAS 21 NOV 27 2019
					QC 21 - SA - 53	

Part Op 100 - (Fabricate per Drwg) 1-Cut Qty 4 D3166-1 as per Drwg D3172 2-Cut 3/4" x 3/4" square tubing as per Drwg D3172 3-Descriptions: Drill holes in D3172-3 as per Drwg D3172 4-Deburr & Remove all markings from material 5-Weld all ribs as per Drwg D3172 using Welding Table 6- Weld top D3174-1 ONLY bottom ones will be welded after mesh is install as per dwg 7- Weld D5365-1 as per dwg in (2) locations. From edge of back basket corn (without hinge) to bottom of D5365-1 lug. And (2) located at the front. 8- Weld mesh as per dwg 9- Use DT10465 jig to locate the bottom D3174-1 as per dwg 110 - (QC9- Inspect visual per QSI004- Fusion Welds) Rod Batch. B136420 120 - QC5- Inspect part completeness to step on W/O 130 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) 140 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) COAT: START TIME: 2:30 FINISH TIME: 3:00 OVEN TEMPERATURE: 2ND COAT: START TIME: 145 - Identify as per dwg & Stock Location: 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2232-3	Basket Hinge	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5171327
D2327-3	Spacer Bushing	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5200139
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Welded Assy-1	5214321
D3166-1	Basket Hoop	4 pcs (4 ea)	100-Large Fab - Welded Assy-1	5195845
D3174-1	Mounting Lug	8 pcs (8 ea)	100-Large Fab - Welded Assy-1	5071099
D5365-1	Lug	4 pcs (4 ea)	100-Large Fab - Welded Assy-1	5200658
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Welded Assy-1	5218434
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	51 ft (51 ea)	100-Large Fab - Welded Assy-1	5177280

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	D2232-3	2	2	0
	D2327-3	2	24	0
	D2581	2	73	0
	D3166-1	4	21	0
	D3174-1	8	15	0
	D5365-1	4	8	0
	M304EX0.75-16F	32	791	0
	M304TS0.750W.065	51	714	0

Part Specifications

Specifications could not be found.

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QSI042)	
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition			
Description Work Order Deviation									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____							